

Date: Monday, 5/15/2006 11:12:00 AM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STA 155 BRACKET
Job Number	: 27112		
Estimate Number	: 11039		
P.O. Number	: N/A	Part Number	: D28041
This Issue	: 5/15/2006 S.O. No. : N/A	Drawing Number	: D2804 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 5/15/2006 Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 26164	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 5/30/2006
Checked & Approved By	: 06.05.15	Qty:	20 Um: Each
Comment	: Est. A00.11.06 New Issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"
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Comment: Qty.: 0.7875 f(s)/Unit Total: 15.7500 f(s) M9878 (2 piece).

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: M10627

MS. 06.05.25 20

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks per template DT8534

SD 06.05.25 20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA103

SD 06.05.25 20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 06.05.25 20

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SD 06.05.30 20

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Tumble &amp; Deburr

SD 06.05.31 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 20/06/07

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 5/15/2006 11:12:00 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 27112

Part Number: D28041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



*060601*

(20)

Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*06/06/02*

(20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*ST 159*

*06/06/02*

(20)

*06/06/01*

20

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/06/03*

(20)

Job Completion



*W 06/06/05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	27112
Description: Bracket		Part Number:	D2804-1
Inspection Dwg: D2804	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.625	+/-0.010					
Ø0.757	+0.005/-0.000	0.757	/			
0.608	+0.000/-0.001					
Ø0.191	+0.005/-0.000	0.191	/			
1.420	+/-0.001	1.420	/			
Ø0.507	+0.000/-0.001	0.507	/			
0.250 deep	+/-0.010	.255	/			
Ø0.507	+0.000/-0.001	0.507	/			
Ø0.191	+0.005/-0.000	0.192	/			
6.933	+/-0.010	6.933	/			
7.578	+/-0.010	7.578	/			
0.437	+0.000/-0.001					
2.654	+0.000/-0.001					
12.304	+/-0.010	12.304	/			
0.125	+/-0.010	.128	/			
0.500	+/-0.010	.501	/			
0.125	+/-0.010	.132	/			
0.250	+/-0.010	.252	/			
0.875	+0.000/-0.001	.875	/			
0.250	+0.000/-0.005	.250	/			

Measured by: SA	Audited by: J.G	Prototype Approval:	N/A
Date: 06.05.25	Date: 06/05/25	Date:	N/A

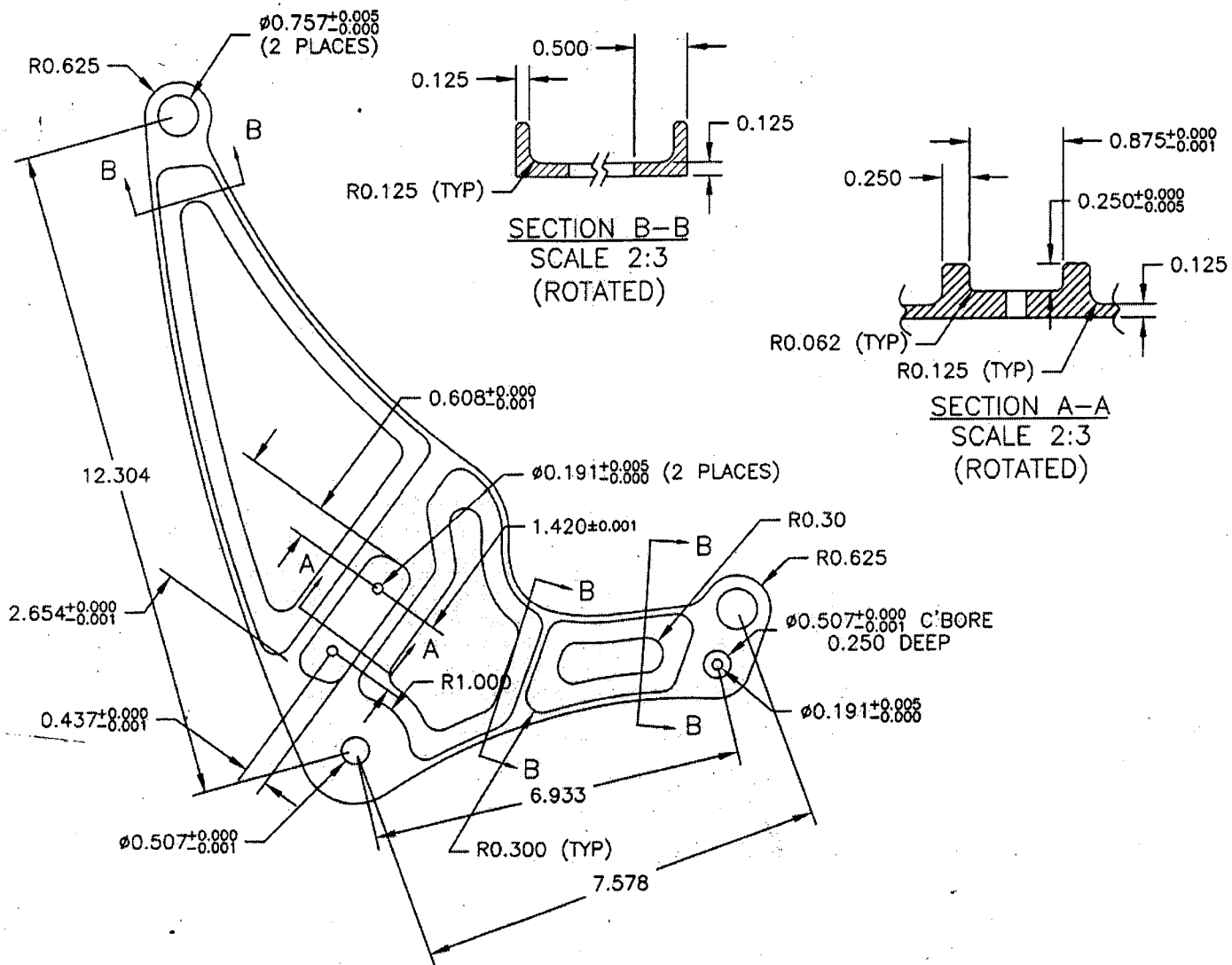
Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	SHEET 1 OF 2
				D2804	
DATE	04.11.22			TITLE	SCALE
				STA 155 BRACKET	1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	

RELEASED

05.03.11

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

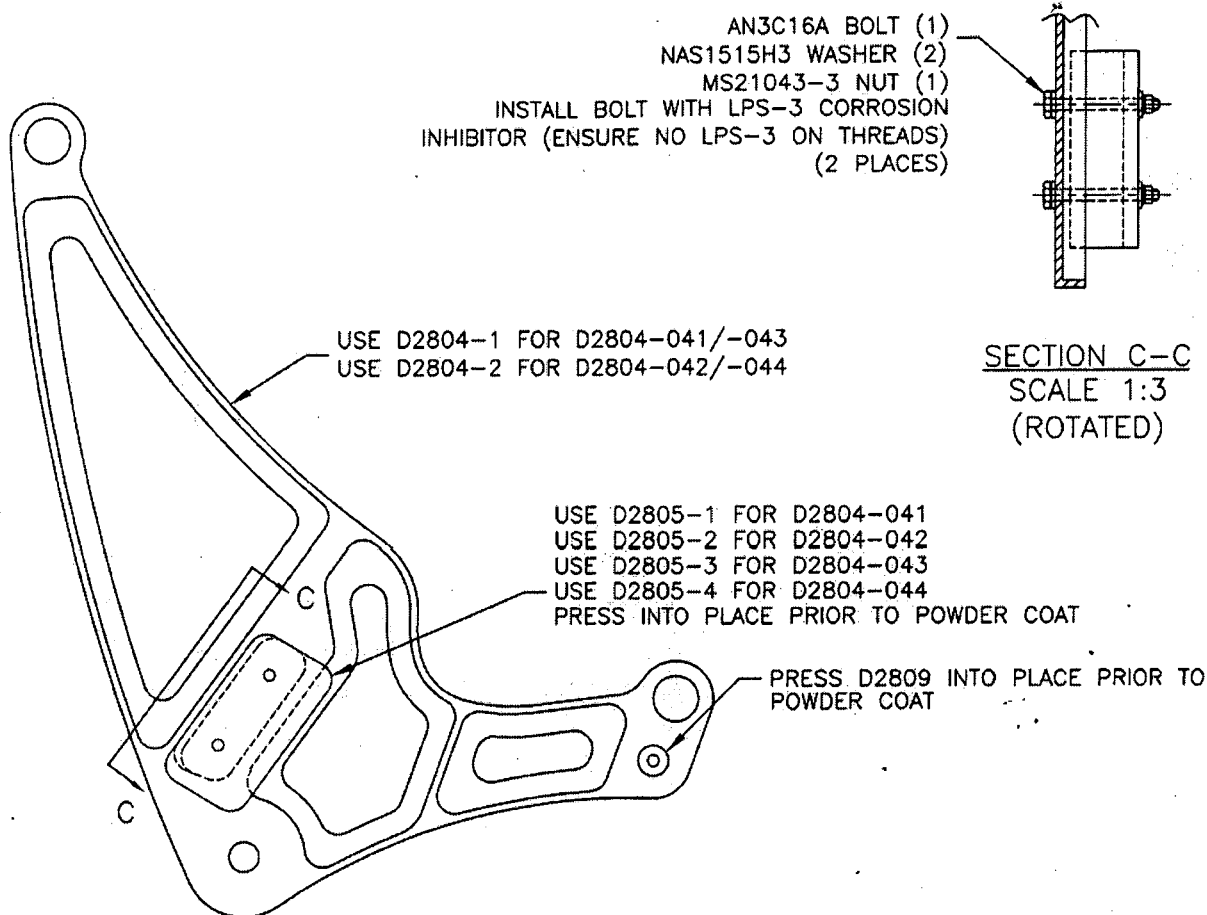
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**DART**

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CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D2804	SHEET 2 OF 2
DATE	TITLE		SCALE
04.11.22	STA 155 BRACKET		1:3



SECTION C-C  
SCALE 1:3  
(ROTATED)

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**D2804-041/-043 BRACKET ASS'Y (SHOWN)**  
**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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